

Work Order ID 53249

October 28, 2009 1:57:18 PM



Page 1

Item ID: PB67-43001-45

Accept



Setup Start



Revision ID: C

Stop



Item Name: Longitudinal Support

Start Date: 10/29/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 11/16/2009 Req'd Qty: 1.00

Customer:

Reference:-

Approvals: Process Plan: MF Date: 09-10-28 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

B67-43001	c
-----------	---

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1- Align drill -97 and -357 using existing pilot hole of -357 as per dwg ✓

2- install spring pin ✓

(1x) Cpl 09/12/10

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

⇒ 8 09/12/17

(X)

120

Green Sandtex(Ref:4.3.5.8) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 2:30
OVEN TEMPERATURE: 320°
FINISH TIME: 3:00

BK 09-12-17

(1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC

Quality Control

QC3- Inspect Part Finish

0.00

M 09-12-17

Memo

0.00

VC

Ø

140



Small Fab

Small Fab

Small Fab

Memo

Assemble parts as per dwg

0.00

0.00

P/L 09/12/31

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

2) S 10/01/04

Memo

0.00

TC

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



Packaging

Identify as per dwg & Stock Location: SA

0.00

Memo

0.00

Packaging

170



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

10/29/0910/01/09BM 10-1-06

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Work Order ID: 53249

Parent Item: PB67-43001-45RevC

Parent Item Name: Longitudinal Support





Comments:

Start Date: 10/29/2009

Required Date: 11/16/2009



Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
PB67-43001-97RevC		Manufactured	No			100	Each	0.0000	1.0000			
												
Clevis												
PB67-43001-357RevB1		Manufactured	No			100	Each	11.0000	1.0000			
												
Tube Arm												



341369 → ① ✓ P10/9/12/16

P10/9/12/16

<u>Warehouse</u>				<u>Loc Qty</u>	<u>Loc Code</u>		
<u>Location</u>							
Main Warehouse							
ST				11			
41508				11			
240-107	Purchased	No		100	Each	74.0000	1.0000
							
SPRING SLOTTED PIN							

① Dex ✓

P10/9/12/16

				<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
				<u>Location</u>		
				Main Warehouse		
				ST	74	
				112813	74	
D3447-1RevA	Manufactured	No		140	Each	11.0000 1.0000
						
Round Spacer						

① ✓

P10/9/12/16

Warehouse				Loc Qty		Loc Code	
Location							
Main Warehouse							
ST				11			
41179				3			
41458				8			

① ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 53249



Parent Item: PB67-43001-45RevC



Parent Item Name: Longitudinal Support

Start Date: 10/29/2009

Required Date: 11/16/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3447-5RevA Clevis		Manufactured	No			140	Each	16.0000	1.0000			

Pl 09/12/16

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	16	
39967	1	
41459	15	

①✓

30345T21



LANYARD

Purchased

No

140

Each

41.0000

1.0000

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	41	
17828	41	

①✓

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 53249

Parent Item: PB67-43001-45RevC

Parent Item Name: Longitudinal Support


Comments:

Start Date: 10/29/2009

Required Date: 11/16/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN4-13A  Bolt		Purchased	No			140	Each	289.0000	1.0000			

M/13359 → ①
M/1359
Pl 09/12/16

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST 289

107321 1

107534 5

107959 23

109285 37

110552 66

110865 3

111477 9

111925 7

112314 138

17406 0

51764 0

BSP43 Purchased No 140 Each 114.0000 1.0000



RIVET



Pl 09/12/16

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST 114

109119 20

110704 50

111127 44

① ✓

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 53249

Parent Item: PB67-43001-45RevC

Parent Item Name: Longitudinal Support

Comments:

Start Date: 10/29/2009

Required Date: 11/16/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS17984-C410		Purchased	No			140	Each	20.0000	1.0000			
QUICK PIN REPLACEMENT												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

20

111119

15

18118

5

MS21042L4

Purchased

No

140

Each

5,920.000

1.0000

Nut

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

5920

110507

184

111827

5727

112314

9

15924

0

6/10/12/15

① ✓

6/10/12/16

① ✓

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 53249

Parent Item: PB67-43001-45RevC

Parent Item Name: Longitudinal Support



Comments:

Start Date: 10/29/2009

Required Date: 11/16/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS1149D0416J  Washer		Purchased	No			140	Each	175.0000	2.0000			
<div> <div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST</div> <div>10538</div> <div>13910</div> </div> <div> <div>Loc Qty</div> <div>175</div> <div>77</div> <div>98</div> </div> <div> <div>Loc Code</div> </div>												
NAS1149DN416J  Washer		Purchased	No			140	Each	0.0000	1.0000			

Pl 09/12/16

② ✓

M13910 → ① Pl 09/12/16

W/O:		WORK ORDER CHANGES					
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#53249

B67-43001-45 LONGITUDINAL SUPPORT

ITEM	QTY -45	P/N	DESCRIPTION
1	X	B67-43001-45	LONGITUDINAL SUPPORT
3	1	B67-43001-97	CLEVIS
4	1	B67-43001-357	TUBE ARM
5	1	D3447-1	ROUND SPACER
6	1	D3447-5	CLEVIS
8	1	30345T21	LANYARD
9	1	AN4-13A	BOLT
10	1	CR3213-4-2	RIVET (OR BSP43-2)
11	1	MS17984-C410	QUICK RELEASE PIN
12	1	MS21042L4	NUT
13	1	MS171534	SPRING SLOTTED TENSION PIN (OR 240107)
14	2	NAS1149D0416J	WASHER
15	1	NAS1149DN416J	WASHER

RELEASED
2009-09-24

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 13 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.	MB	09.06.25
REV.	DESCRIPTION	BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AS	DRAWING NO.	REV. C
CHECKED	AS	B67-43001-45	SHEET 1 OF 2
MFG. APPR.	AS	TITLE	SCALE
APPROVED	AS	LONGITUDINAL SUPPORT	NTS
DE APPR.	N/A	DATE 09.06.25	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

B67-43001-97
2 CLEVIS

B67-43001-357
2 TUBE ARM

10 CR3213-4-2 RIVET
NAS1149DN416J WASHER
(30345T21 LANYARD NOT SHOWN
ON THIS VIEW FOR CLARITY)

D3447-1
ROUND SPACER

AN4-13A BOLT
NAS1149D0416J WASHER, 2X
MS21042L4 NUT

MS17984-C410
QUICK RELEASE
PIN

10 30345T21 LANYARD

MS171534 2 8
SPRING SLOTTED TENSION PIN

D3447-5
CLEVIS

9
2 PL

B67-43001-45 LONGITUDINAL SUPPORT

RELEASED
2009-09-24

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.99 lbs
- 8) PRIOR TO POWDER COAT, ALIGN B67-43001-97 ON B67-43001-357 AS SHOWN AND DRILL A $\phi 0.129$ HOLE THROUGH BOTH PARTS.
FASTEN B67-43001-97 TO B67-43001-357 USING MS171534 SPRING SLOTTED PIN.
- 9) MASK PRIOR TO POWDER COAT
- 10) BEFORE OR AFTER POWDER COAT, DRILL A $\phi 0.129$ HOLE IN B67-43001-357 TO INSTALL THE LANYARD. DRILL THROUGH ONE WALL ONLY.
AFTER POWDER COAT, INSTALL 30345T21 LANYARD ON B67-43001-357 AS SHOWN USING CR3213-4 TYPE RIVET AND NAS1149DN416J WASHER.

DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AS		
CHECKED	AD	DRAWING NO. B67-43001-45	REV. C
MFG. APPR.	N/A	TITLE LONGITUDINAL SUPPORT	SHEET 2 OF 2
APPROVED	N/A	SCALE	NTS
DE APPR.	N/A	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	09.06.25		

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